

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023137**Date Inspected:** 23-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Lin, CWI Sun Tian Liang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG (see photo below)

PCMK: X3305K-017

Weld No: 001,002

Welder: 045143

WPS-B-T-2233-ESAB

Components; OBG

PCMK: X3305K-006

Weld No: 001,002

Welder: 045240

WPS-B-T-2233-ESAB

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Components; OBG  
PCMK: BK017-001  
Weld No: 002  
Welder: 040434  
WPS-B-T-2233-ESAB

Components; OBG  
PCMK: BK015-001  
Weld No: 008  
Welder: 052763  
WPS-B-T-2233-ESAB

Components; OBG  
PCMK: BK016-001  
Weld No: 006, 007  
Welder: 040474  
WPS-B-T-2233-ESAB

Components; OBG  
PCMK: BK015-001  
Weld No: 009  
Welder: 044473  
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhong Lin, CWI Sun Tian Liang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG  
PCMK: BK017B-001  
Weld No: 015  
Welder: 052763  
Repair No. B-WR20753  
WPS-345-SMAW-2G(2F)-Repair-1

Components; OBG  
PCMK: TR3008TR2-001  
Weld No: 021  
Welder: 066674  
Weld Repair No. B-WR20714  
WPS-345-SMAW-2G(2F)-Repair-1

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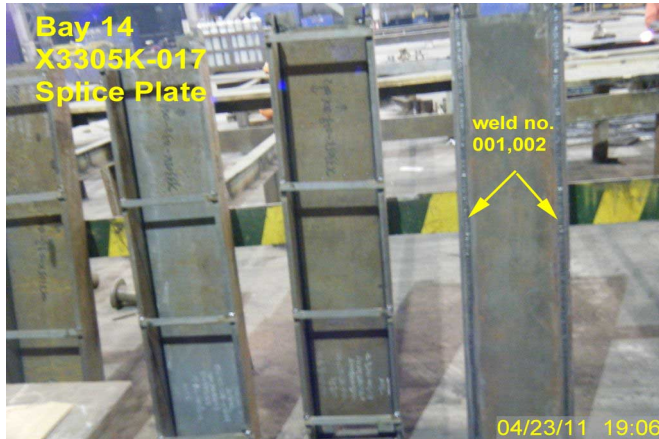
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This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in OBG Segment 12 Splice Plate X3305K-004 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

“No relevant conversations.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly	Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken	QA Reviewer
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